

Work Order ID 66599

Tuesday, February 22, 2011 1:28:57 PM



Page 1

Item ID: D3188-6

Accept



Setup Start



Revision ID:

Item Name: Spacepod Body

Stop



Start Date: 2/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date:

102-27 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

Draw Nbr

Revision Nbr

D3188

Rev F

100



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Check for void spot and pins.

MF 11.07.06 03

110

Identify as per dwg & Stock Location: *Loc 102-27* 0.00

Packaging

Memo

0.00

Packaging

BT 11.07.06

120



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/16/06

MF

2 2

11-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 22, 2011 1:29:02 PM

Page 1

Work Order ID: 66599



Parent Item: D3188-6



Parent Item Name: Spacepod Body

Start Date: 2/22/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-05 New Issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3188-2M 		Manufactured	No		66602	100	Each	1.0000	1	1		 8T 11-07-06	

SPACEPOD BODY RH

Location	Loc Qty	Loc Code
CA	1	
46180A	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
 12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
 18 oz ROVING "E" GLASS (18 oz CLOTH)
 OWENS CORNING MILLED FIBERS, "E" GLASS
 3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
 OR DIVINYCELL
 OR AIREX
 OR KLEGECCELL
 FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M-/1-5	DT8003	DT8501
D3188-2M-/2-6	DT8004	DT8502
D3188-3M-/3-7	DT8500	DT8501

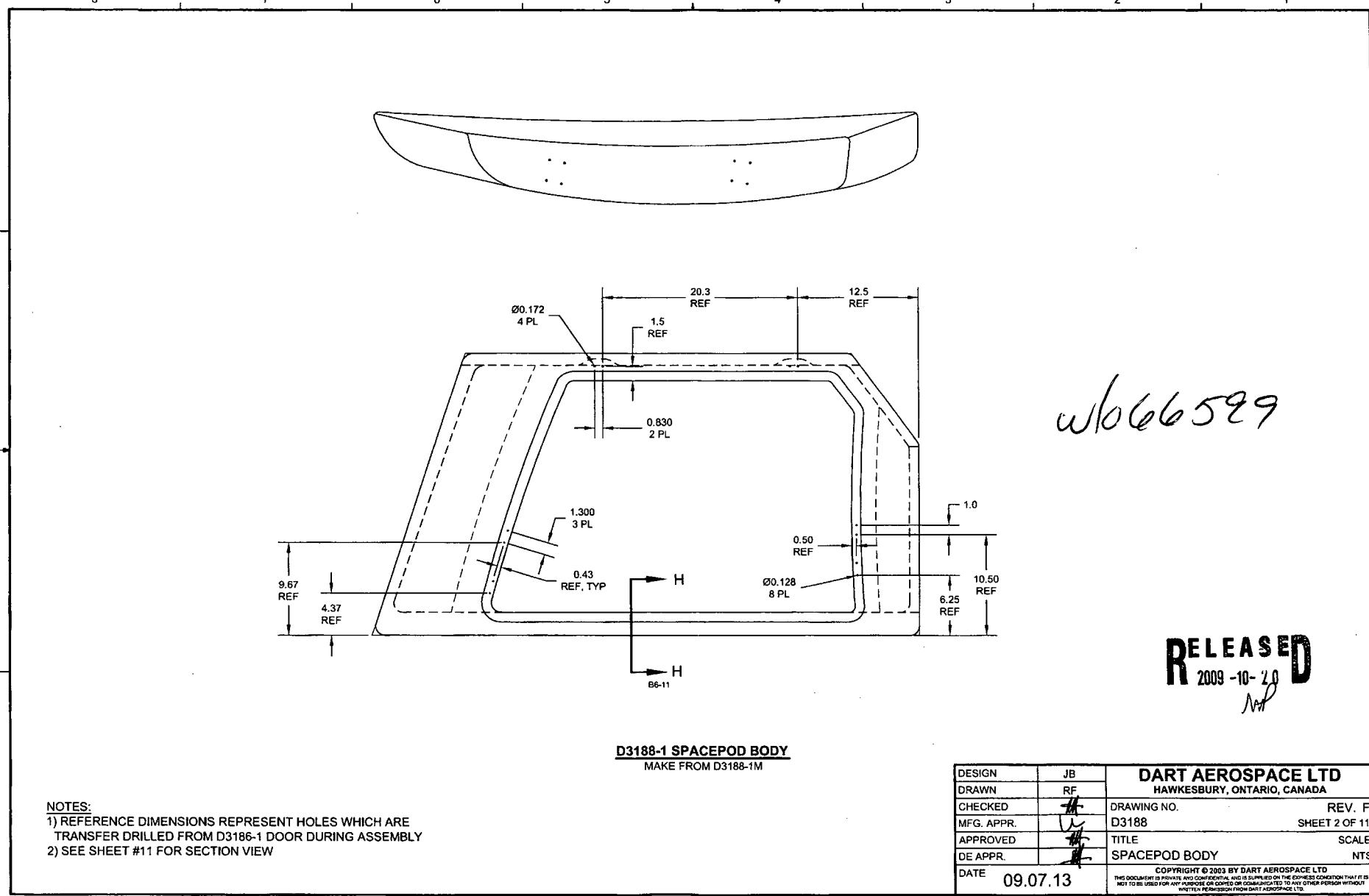
- 2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
 APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3188-1 = N/A
 D3188-2 = N/A
 D3188-3 = N/A
 D3188-5 = N/A
 D3188-6 = N/A
 D3188-7 = N/A
- 8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

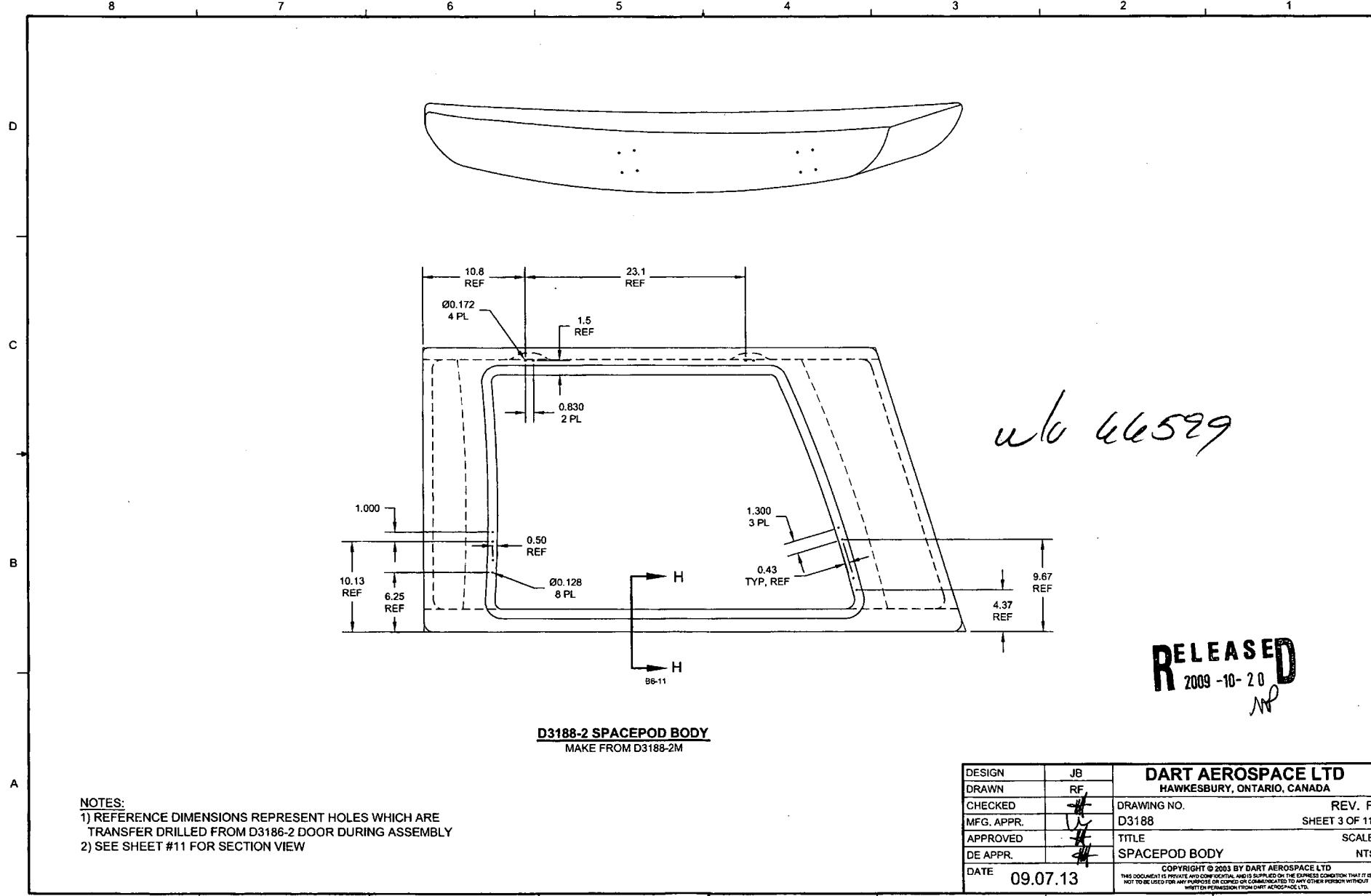
SHOP COPY
 RETURN TO
 ENGINEERING
UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *001399*
01/11/02-JD

RELEASED
2009-10-20
MP

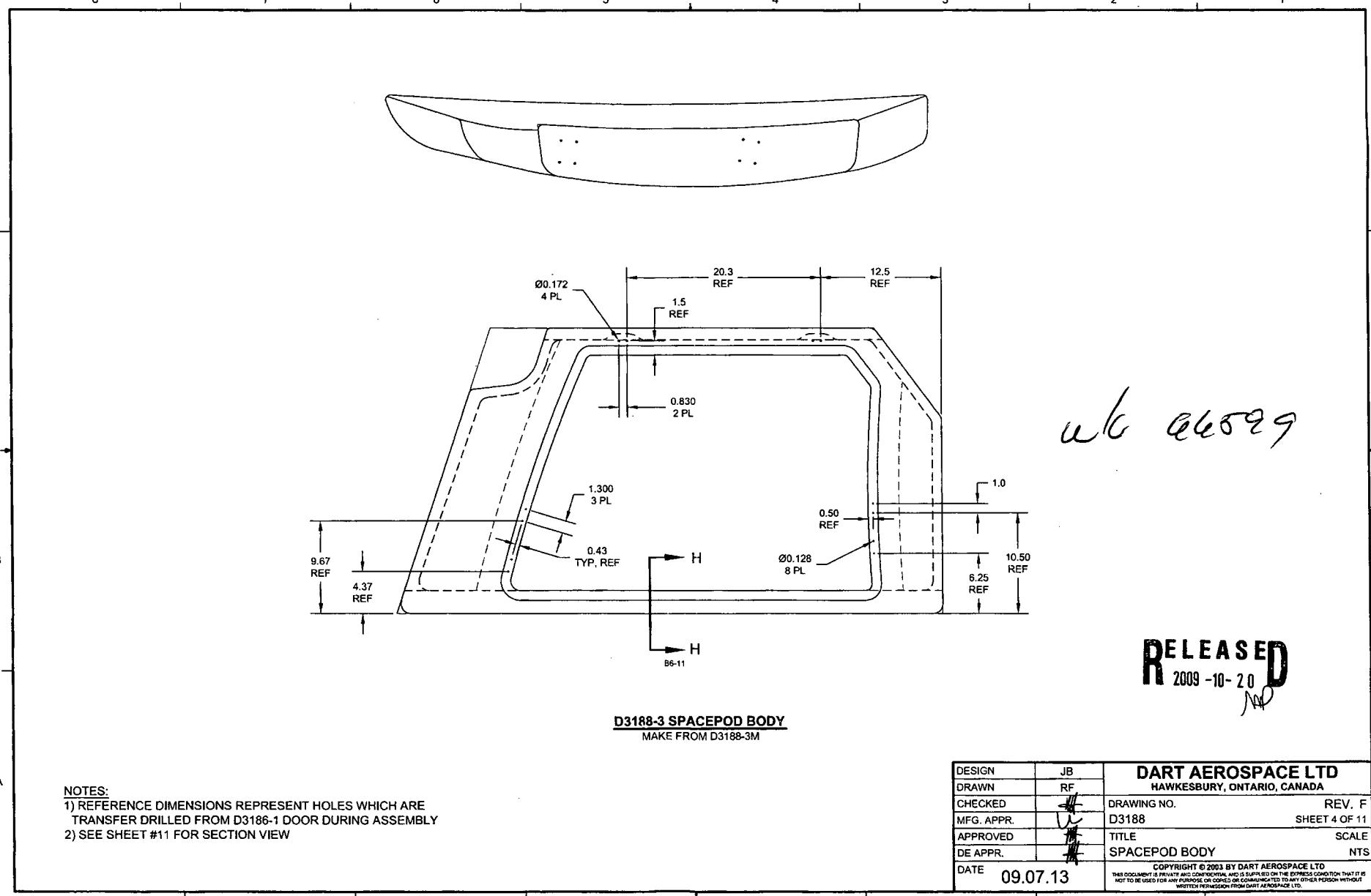
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M-/2M-/3M-/5I-/6I-/7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MM</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>MM</i>	D3188	SHEET 1 OF 11
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE WHATSOEVER BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

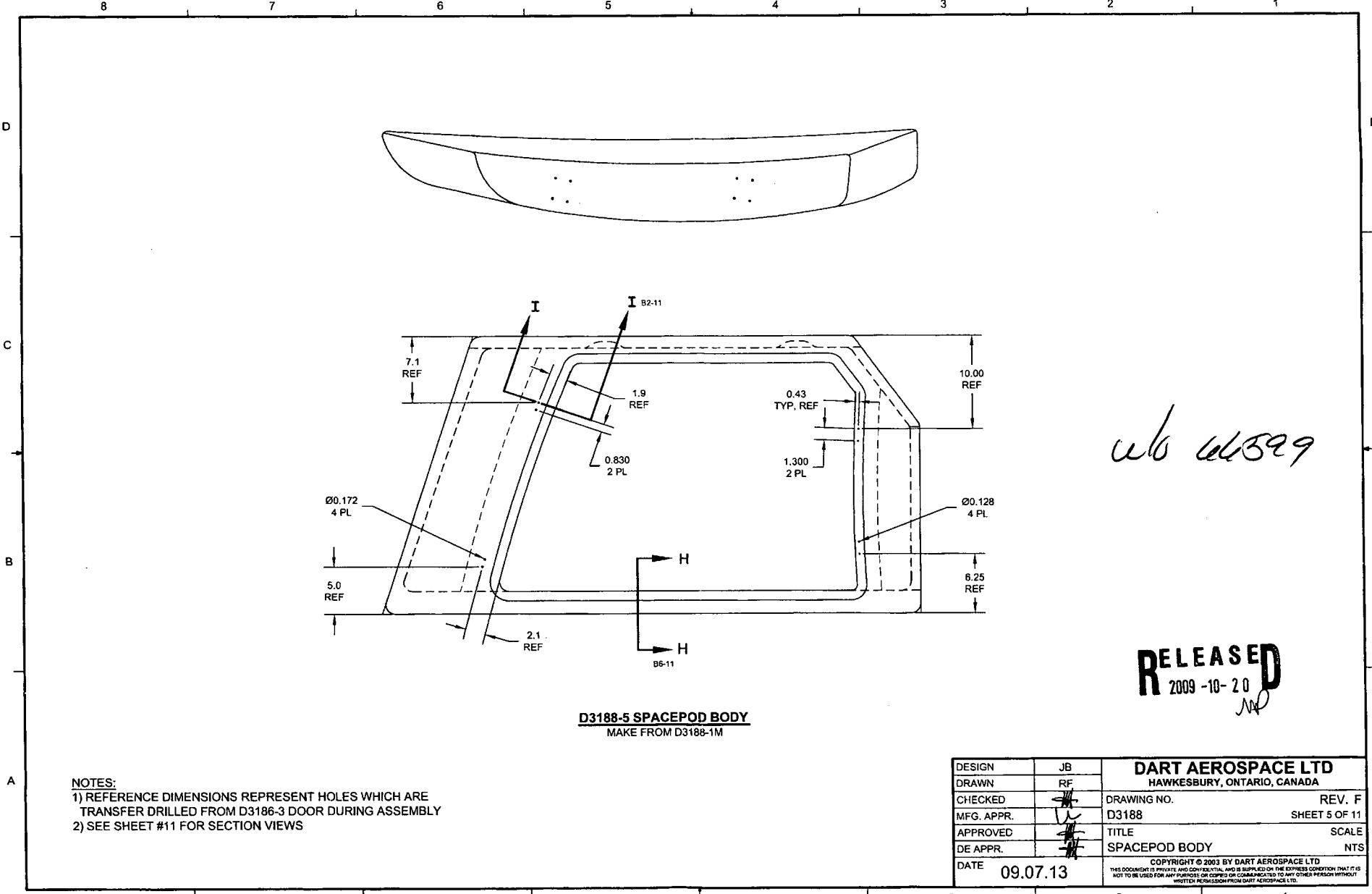
8 7 6 5 4 3 2 1



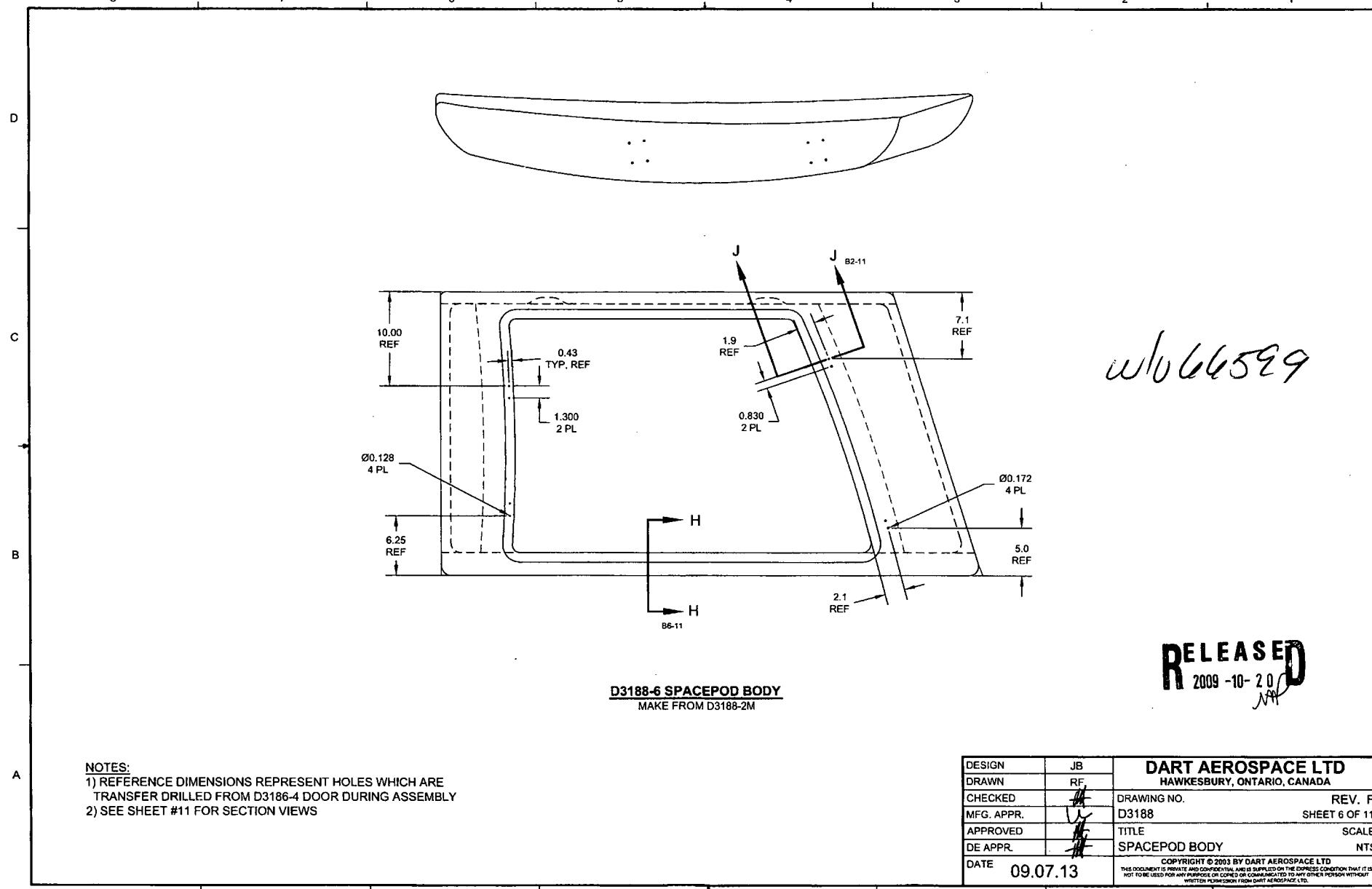


DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<input checked="" type="checkbox"/>	REV. F	
MFG. APPR.	<input checked="" type="checkbox"/>	D3188	SHEET 3 OF 11
APPROVED	<input checked="" type="checkbox"/>	TITLE	SCALE
DE APPR.	<input checked="" type="checkbox"/>	SPACEPOD BODY	NTS
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

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D

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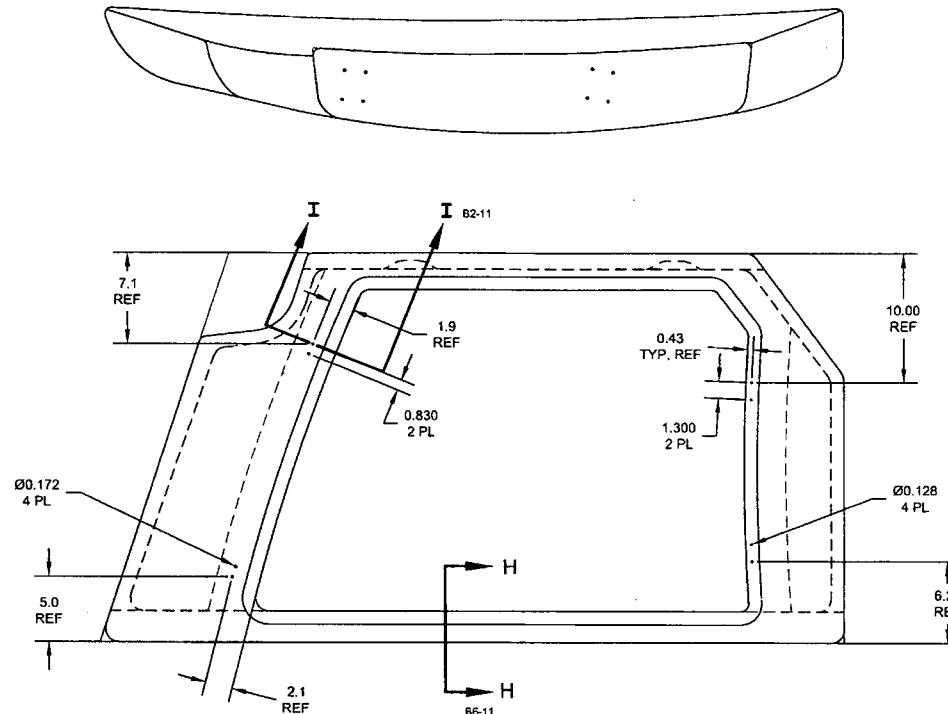
C

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B

A

A

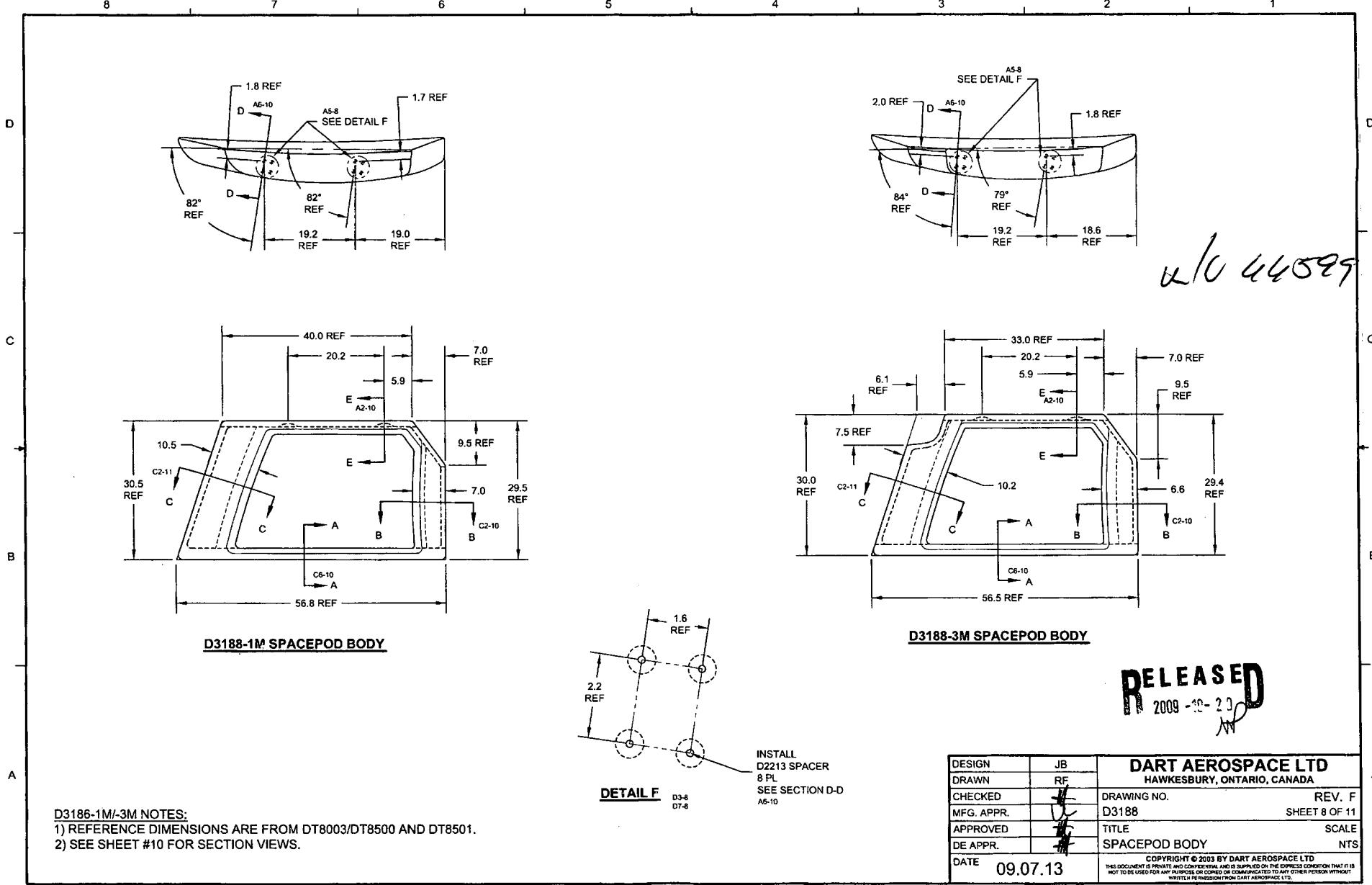


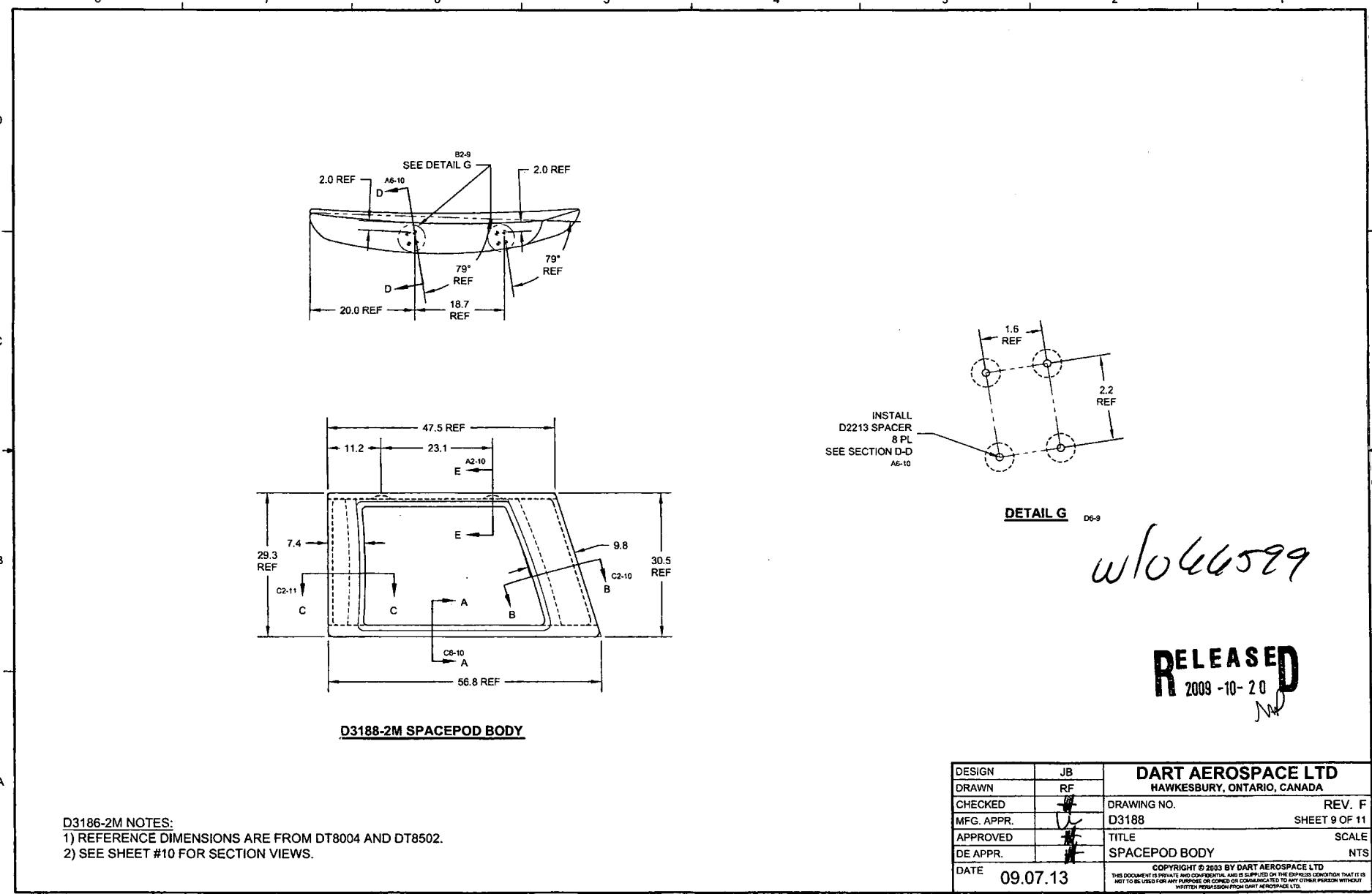
D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

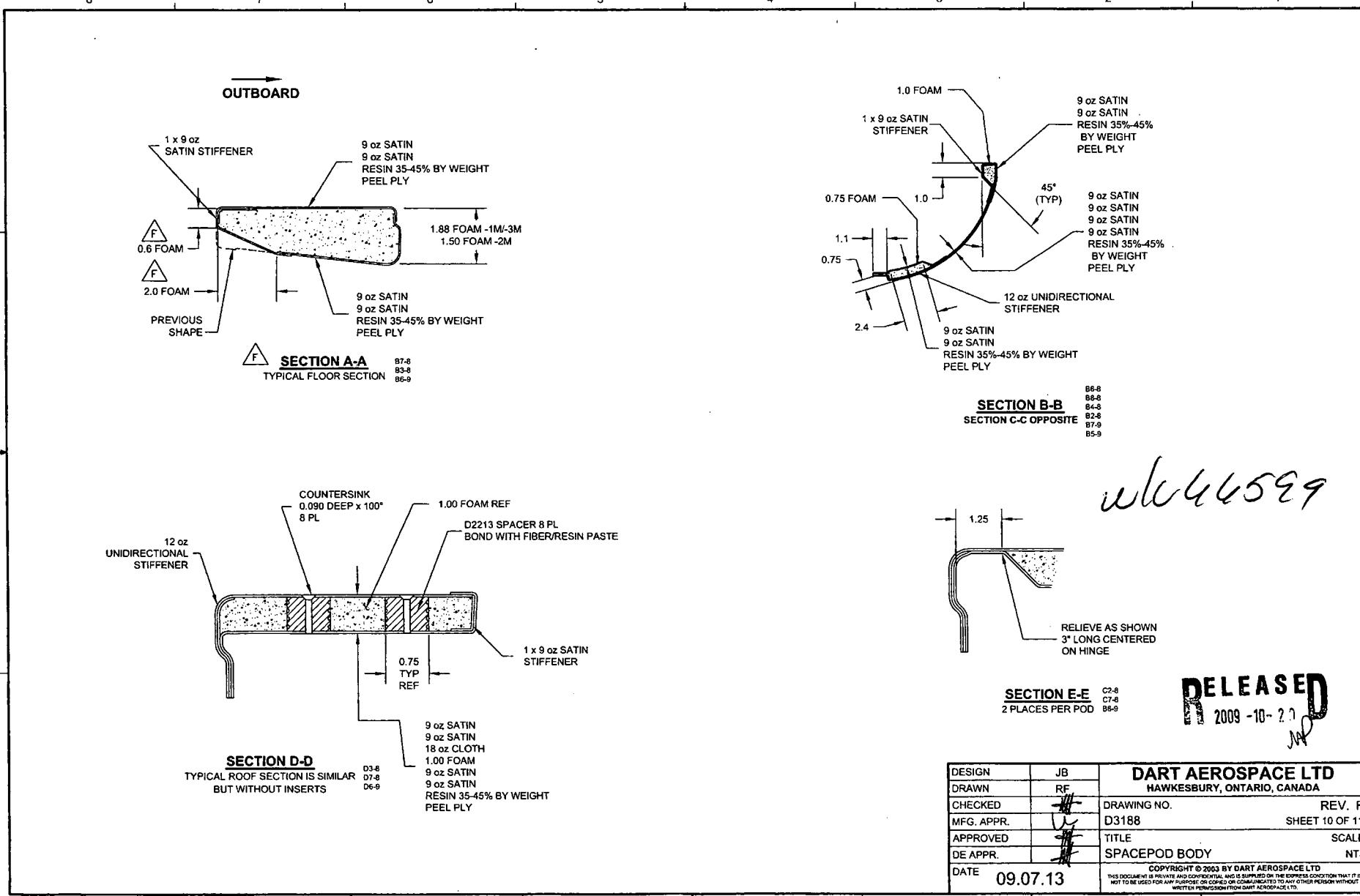
NOTE:
 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
 TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
 2) SEE SHEET #11 FOR SECTION VIEWS

8 7 6 5 4 3 2 1

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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8 7 6 5 4 3 2 1

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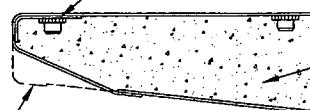
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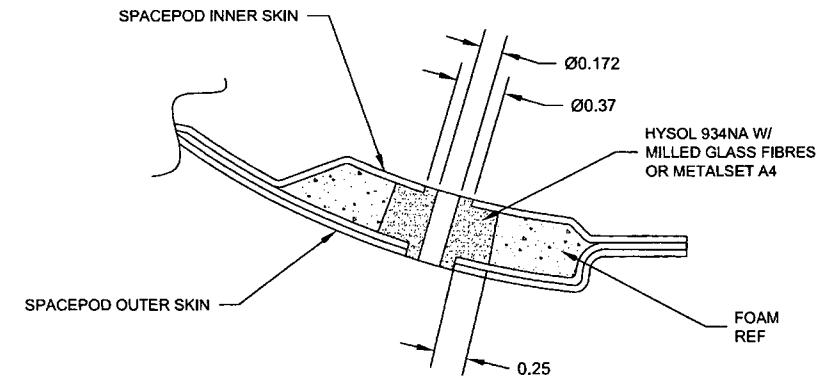
A

OUTBOARD

INSTALL AKS7-1032-130
INSERTS 29 PL
PER D3188-1T1 (D3188-1/3-5/7)
OR D3188-2T1 (D3188-2/6)



A5-2
A5-3
A5-4
A5-5
B5-6
B5-7



SECTION H
SECTION J-J OPPOSITE
4 PLACES PER POD

C5-5
C4-6
C5-7

w/0 46599

RELEASED
2009-10-20
NP

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. F
MFG. APPR.	W	D3188	SHEET 11 OF 11
APPROVED	#	TITLE	SCALE
DE APPR.	#	SPACEPOD BODY	NTS
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